

Sterling Silver MAG

Purpose - Casting

Advantages - Heat treatable, very hard, no fire scale

Physical & Mechanical Properties

Composition		Density (g/cc)	Hardness (HV)	
Ag	92.60%		10.61	As cast
Cu	3.90%	1 stage hardened		98
Pt	3.50%	2 stage hardened		101

Melting & Casting Instructions

Temperatures			Process parameters	
Casting	1010° - 1040° C	1850° - 1904° F	Quench Time	25-30 minutes
Flask	595° - 675° C	1103° - 1247° F	Remelting	50% fresh mix

Heat treatment Instructions

(1) 1 Stage Hardening process for medium to high hardness:

Heat the sample at 450° C for 1 hour and air cool.

(2) 2 Stage Hardening process for super high hardness:

Stage 1 - Anneal the sample at 700° C for 15 - 25 minutes (depending on the size) & quench in water.

Stage 2 - Heat the sample at 450° C for 1 hour and air cool

Note: Cover the object with slurry of Borax / Boric acid paste to protect the surface from discoloration.

General Instructions

- **Fluxing:** It may be necessary to flux these silver melts. We recommend Boric Acid. Do not use Carbon Containing Fluxes or Charcoal. Skim any surface oxides off the surface before stirring.
- **Investment removal:** *Flouric based* investment removers are the best for silicon oxide invisible coating. Use of aggressive acid causes corrosion and surface damage. *United's brite cast* works very effectively.
- To calculate the weight of the metal needed (in grams), multiply density (gm/cc) with weight of wax (grams). Add 10% of the total weight for button.

Note: There are proprietary metals in the formulation which are not included in the composition section.

Technical Assistance: Always available... Call: **1-800-999-3463 / 1-800-999-FINE**

E-mail: techteam@unitedpmr.com Web-Site: www.unitedpmr.com